

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013315**Date Inspected:** 17-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang, Tu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Tower Miscellaneous (Tower Grating Support & Tower Ladder)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as Tower miscellaneous Components. The weld designations reviewed are as follows.

PE-5-43, 20, 37, 10

PE-3-33, 32, 42

SSD1-LASA4-1

SOUTH TOWER LIFT 1, CABLE TRAY ON SKIN C

This QA inspector performed green tagging for the following components.

Cable tray on skin C, South Tower lift 1: Green Tag No. 11649

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This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10

NORTH TOWER LIFT 5, AE CORNER SEAM

SMAW welding of weld joint 22A & 40A located on NSD1-TL5-3B-F.

Welder is identified as 052493. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

TOWER FACADE PLATE

FCAW welding of weld joint 9 located on SD1-SFSA4-29A/B.

Welder is identified as 053870. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

SAW welding of weld joint 11 located on SD1-SFSA4-30A/B.

Welder is identified as 040489. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S.

FCAW welding of weld joint 23 located on ED1-SFSA3-14.

Welder is identified as 057180. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

NORTH TOWER LIFT 5, DE CORNER SEAM

This QA inspector witnessed the Ultrasonic Testing (UT) performed by ZPMC NDT personnel on the weld joints NSD1-TL5-3B-F-79B & NSD1-TL5-3B-F-1A of DE corner seam of North Tower lift 5.

BAY 11

TOWER GRILLAGE PLATE

SAW welding of weld joint 9B located on GTSA5-B/G.

Welder is identified as 042195. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

SAW welding of weld joint 10B located on GTSA5-B/G.

Welder is identified as 047304. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

TOWER SKIRT PLATE

SMAW welding of weld joint 9 located on WD1-A597B/C-2.

Welder is identified as 040655. ZPMC QC is identified as Mr. Zhao Mao Mao.

The welding variables recorded by QC appeared to comply with WPS-B-T-2114.

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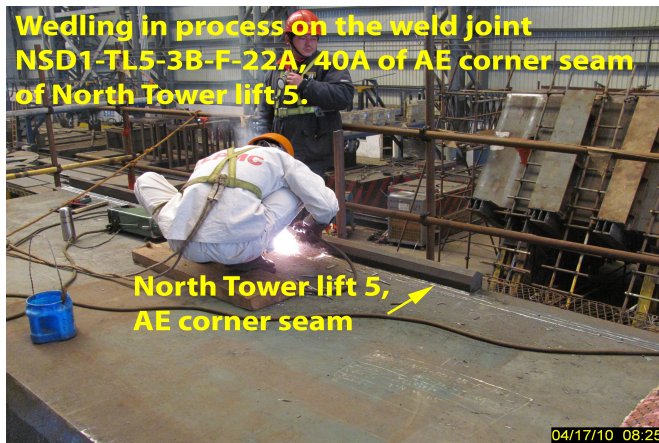
WEST TOWER LIFT 4, DE CORNER REPAIR (T-CWR606, REV. 1, Y=26100)

SMAW welding of weld joint 61A/B (Repair) located on WSTL4-2B/L.

Welder is identified as 202323. ZPMC CWI is identified as Mr. Li Lin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-REPAIR.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
